

Date: Thursday, 3/8/2007 1:39:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 SKIDTUBE
Job Number	: 31005		
Estimate Number	: 10465		
P.O. Number	: N/A	Part Number	: D058672011
This Issue	: 3/8/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 31008	Material	: N/A
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.03.08</u>		
Comment	: Est Rev: 02.06.24 Re-format; CHG002 (MPP2251); ECN 258 K J Est Rev:G 07-03-08 As per IIN D058-672 Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-011 CHG003

KS 07.04.03 (1)

2.0	31005A	OH-58 SKIDTUBE ASSEMBLY
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Comment: Sub-Component OH-58 SKIDTUBE ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D058672043	GROUND HANDLING KIT
-----	------------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GROUND HANDLING KIT

Batch: B31131 ✓

5.0	D29321	206 Saddle Left side
-----	--------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2932-1

Saddle

B36280 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31005

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29331

206 Saddle Left



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2933-1

Saddle

B30945 @ ✓ B29232 (10) ✓

7.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B30451 ✓

8.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B30946 ✓

9.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN3-41A

Bolt

1102472 ✓

10.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch =

16 D2652

Bushing

B31298 ✓

11.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

1103962 ✓

*[Handwritten Signature]*  
3/8/07/100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31005

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L3 Nut (or -3)

*1102658 ✓*

13.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-10A Bolt

*1104023 ✓*

14.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-12A Bolt

*1102658 ✓*

15.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD516 Washer

*1102519 ✓*

16.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-6A Bolt

*1102115 ✓*

17.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer

*1102925 ✓*

*[Signature]*  
*3/8/07/160*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

1103914 ✓

19.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

10 D2712 Set Screw

626481 ✓

20.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2968-043 Tow Ring

629353 ✓

21.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch:

15519 ✓

22.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN970-4 Washer

1103344 ✓

23.0

MS210424

USE MS21042L4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

USE MS21042L4

Batch:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes NO DQA: ED Date: 07/05/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31005

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



u 07/4/30



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/4/27 (1)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058672-011

Location:

REV: B 07/04/30

CE

26.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/01

Job Completion



u 07-05-01

31005A

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 SKIDTUBE ASSEMBLY  
 Job Number : 31005A  
 Estimate Number : 10475  
 P.O. Number : *N/A* Part Number : D058672041  
 This Issue : 3/8/2007 S.O. No. : *N/A* Drawing Number : D2922 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : A1  
 Previous Run : 31008A Material : *N/A*  
 Due Date : 4/15/2007 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 07.03.08  
 Comment : Est Rev: C 02.06.28 Re-format; ECN 258 KJ  
 Est Rev: D 06.02.06 Added Dt8025 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D058-672-041 CHG 001 *N/A*

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD *B29398 Pm 07-03-2001*

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube *Pm 07-03-2001*

2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R Aluminum Rod *M103317/M102421 BE 07-03-20*

3-Cut aft end of D2620 bent tube as per dwg D2922 *Pm 07-03-2001*

4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia. *Pm 07-03-2001*

5-Drill holes for wearplates using DT 8487 Open to 0.297" dia. *Pm 07-03-2001*

6-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit *Pm 07-03-2001*

8-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922 *Pm 07-03-2001*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/03/20	3.6	<del>QC 5/9</del> perm. change	MA	07/03/20		1/2 07/03/20	MA 07/03/20

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31005A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Deburr and Blow out all chips form inside the tube

*Pm 07-03-20*

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Pm 07-03-20*

5.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2923

Web

*B2923*

*JD 7-3-21*

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

*Pm 07-03-21*

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

*Pm 07-03-21*

3-Deburr and Blow out all chips from inside the tube

*Pm 07-03-21*

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

*JD 7-3-21*

A/R

Sikaflex-291

*M103497*

Sikaflex expire date: *7-10-1*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*11/07/03/22*

8.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number

Description

Batch

1 D2794

Fwd Cap

*B14400 BE 07-03-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31005A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 D2649

Crossbolt spacer

*BE 29329*

*BE 07-03-23*

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R

Aluminum Rod

*m 102421*

*BE 0703-23*

3-Grind welds flush as per Dwg D2922

*BE 07-03-27*

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

*pm 07-03-27 (1)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/03/29*

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/03/29*

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*FL*

*07/04/03 (1)*

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*2004-05 (1)*

15.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad

*29777*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31005A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-15 Wearshoe

Batch

B29335

17.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-21 Wearshoe

Batch

B29198

18.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2924 Wearshoe

Batch

B29595

19.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 MS27039-1-08 Screw

Batch

M102630

20.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 AN960JD10L Washer

Batch

M102832

FL 07/04/05 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31005A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 ALS4-1032-130 Insert

*M103495*

or (see QSI 017)

22.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description

Batch

20 D2651-1 Plugs

*B30943*

23.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description

Batch

20 D2651-3 O-Rings

*B30815*

24.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2646 Aft Cap

*B30119*

25.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 MS27039-1-08 Screw

*M102630*

*FL 07/04/05* ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31005A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 AN960JD10L Washer

Batch: m102832

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

Sikaflex expire date: 07/10

m103497

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 07/10

m103497

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

m103707

Batch:

FL

07/04/09

①

①

FL  
07/04/05

28.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP 31005 07/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 9/6/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:39:42 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE ASSEMBLY

Job Number: 31005A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

*210705/01*

Job Completion



*U 7105-01*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY SCALE NTS	
A	99.10.14	NEW ISSUE	
A1	<i>[Signature]</i> 01.08.20	$\phi 0.640$ WAS $\phi 0.625$	

RELEASED  
00.05.11 *[Signature]*

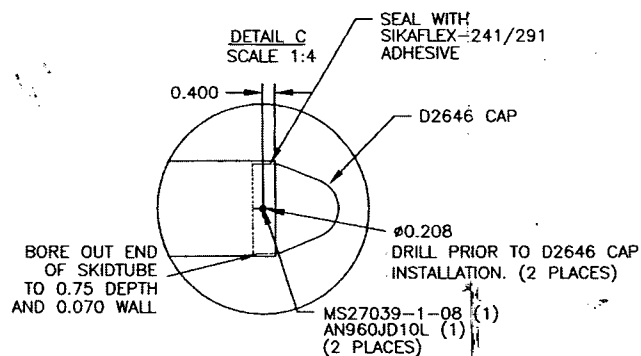
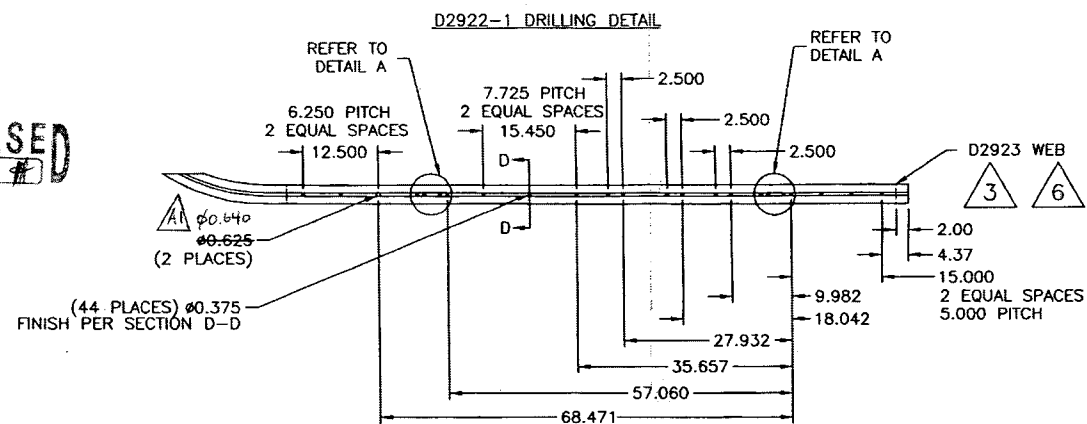
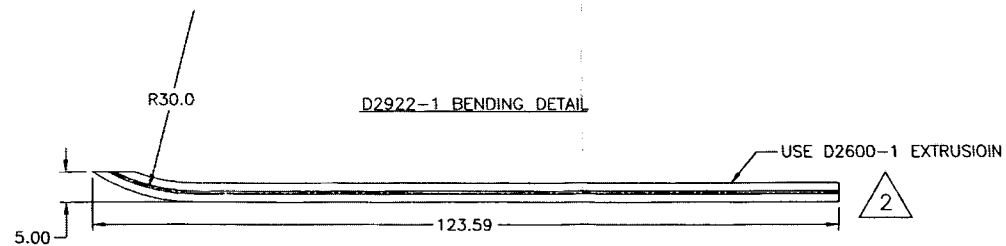
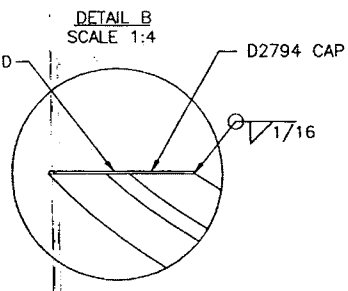
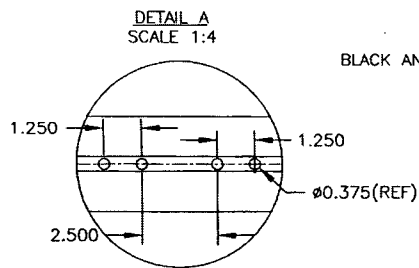
Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP.
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

GENERAL NOTES:

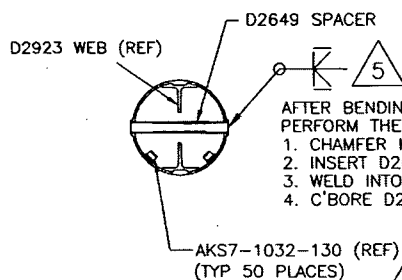
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.\*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART-QSI-015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL  $\phi 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

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WITHOUT NOTICE  
WORK ORDER  
NO. 31005A

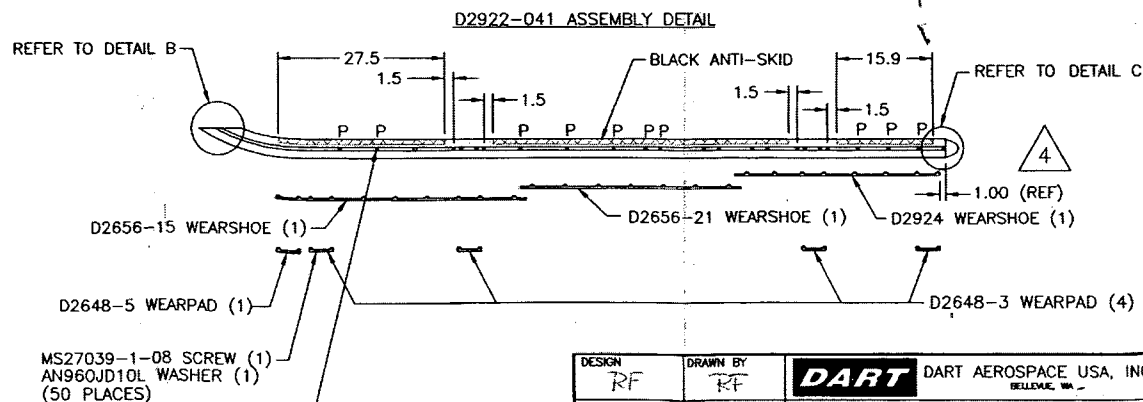




**SECTION D-D**  
SCALE 1:4  
FOR 0.375 HOLES ONLY



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
  2. INSERT D2649 SPACER (22 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE D2649 SPACER TO 0.313 X 0.75 DEEP



MS27039-1-08 SCREW (1)  
AN960JD10L WASHER (1)  
(50 PLACES)

DESIGN RF	DRAWN BY RF	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA	
CHECKED TH	APPROVED TH	DRAWING NO. D2922	REV. A SHEET 2 OF 2
DATE 99.10.14	TITLE OH-58 SKIDTUBE ASSEMBLY		SCALE 1:20

**RELEASED**  
00.05.11

NO. 31005 A  
WORK ORDER  
SUBJECT TO AMENDMENT  
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SHOP COPY



NO. 99

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A0586 72041 / B3 1008A

TEST WELDS REQUIRED

BASE METAL	<u>Alum</u>	WELDING PROCESS	<u>Tig</u>
Penetration	Complete <input type="checkbox"/> Partial <input checked="" type="checkbox"/>	Single Weld <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/>	
Current AC <input checked="" type="checkbox"/> DC <input type="checkbox"/>		Backing YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	
	Position	Vertical	Down <input type="checkbox"/> Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/>	3G <input type="checkbox"/> 4G <input type="checkbox"/>	
Tube Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/>	5G <input type="checkbox"/> 6G <input type="checkbox"/>	
Sheet Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/>	3F <input type="checkbox"/> 4F <input type="checkbox"/>	
Tube Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/>	4F <input type="checkbox"/> 5F <input type="checkbox"/>	
Crossbolt Spacer	Welded into <u>Skidtube</u>		

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/20 Qualifier David Newel